

*Date: Thursday, 19/03/2009 4:30:33 PM
User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BUSHING
Job Number :	46606		
Estimate Number :	10308		
P.O. Number :		Part Number :	D26173
This Issue :	19/03/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2617 REV D2
First Issue :	/ /	Project Number :	N/A
Previous Run :	44360	Drawing Revision :	D2
	Type :	Material :	
	MACHINED PARTS	Due Date :	24/03/2009
Written By :		Qty:	60
Checked & Approved By :	JLD 09.03.19	Um:	Each
Comment :	Est G 04.07.14 Reformat; added step 5 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T0375W058	6061-T6 RD Tube .375 x.058W
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Comment: Qty.: 0.0765 f(s)/Unit Total : 4.5927 f(s)

6061-T6 Round Bar 1.5"

Material : 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6)

Ø0.375" tubing x 0.058" wall

(M6061T6T0.375W.058) Batch: 1110485 09/03/22

60 pcs

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE

Turn as per Folio FA437 and Dwg D2617

09/03/22

60 pcs

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

09/03/22

60 pcs

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JF 09/03/23

60

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr break all unmarked sharp edges 0.005 to 0.010

09/03/22

60 pcs

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/03/2009 4:30:34 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 46606

Part Number: D26173

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



41



Comment: Acid etch and Alodine as per QSI 005 4.1

09-03-23

(60)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

#

09/03/23 cantis

(x60)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 39

SS 09/03/24 (x60)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/24

Job Completion



MF
09-03-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

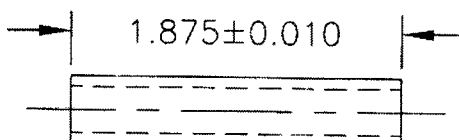
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

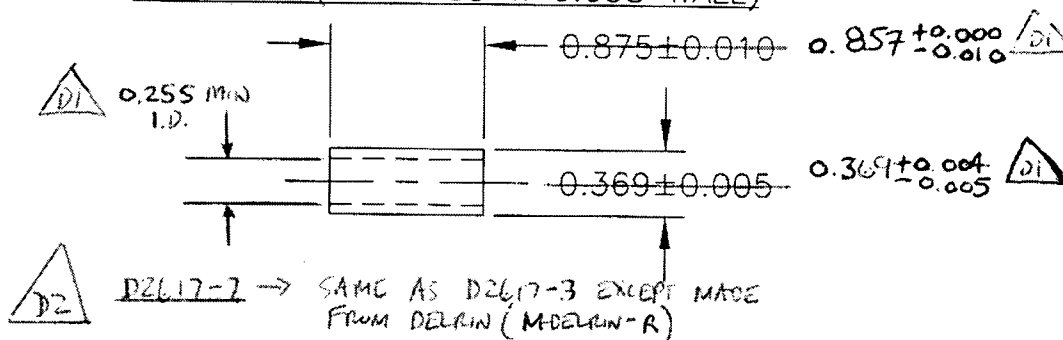


DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2617	REV. 0 SHEET 1 OF 1
DATE 01.07.04				TITLE BUSHING	SCALE 1:1
DL 04.04.10 #1P ADD D2617-7					
A				96.10.08	NEW ISSUE
B				97.05.08	.875 WAS 1.125
C				97.06.04	0.369 DIA WAS 0.375
D				01.07.04	ADD MAT'L SPEC AND TOL./DIM. NOTE
D1				04.07.12	CORRECT TOLERANCE (NCR 774)

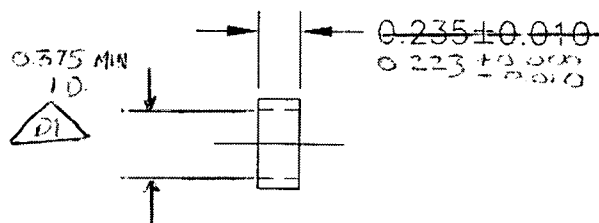
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED
01.07.05

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 110606

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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